



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4202-1

Job Sheet 182760



Part No: D4202-1

Job Qty: 150 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/31/18

Job Tracking No:

Due Date: 9/21/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-12-07 JLM VERIFIED:DD IPP REV:B AS PER REV B 11-04-05 JLM
VERIFIED BY:DD IPP Rev:C 11.12.19 PER DWG REV.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	150 Ea	9/21/18	9/21/18	0.00	0.00	Start Up Machining-2	VHJ	JSD 18/10/25
100	Hardinge	150 pcs	9/21/18	9/21/18	0.00	6.38	Hardinge	VHJ	" "
120	QC	150 pcs	9/21/18	9/21/18	0.00	0.00	QC8		Kt 18-10-25
130	Outsource	150 pcs	9/21/18	9/21/18			MEI001-VC	9	CT 18-10-25
140	Packaging	150 pcs	9/21/18	9/21/18	0.00	0.00	Packaging2		18 NOV 07 2018
150	QC	150 pcs	9/21/18	9/21/18	0.00	0.00	QC6		NOV 07 2018 68
160	HandFinish	150 pcs	9/21/18	9/21/18	0.00	0.75	HandFinish4		M66 9-89
190	Packaging	150 pcs	9/21/18	9/21/18	0.00	0.00	Packaging3-2		M66
200	QC21-SA	150 Ea	9/21/18	9/21/18	0.00	0.00	QC21		NOV 08 2018

Part Op 100 - 1- Machine as per Folio FB015 ***DO NOT CHAMFER OUTSIDE DIA***
 Descriptions: 130 - ***HEAT TREAT AS PER DWG D4202*** Mat'l: 6061-T6 Aluminum Tubing Per WWT-700/6
 160 - WASH SPACER AS PER QSI005
 190 - ***STOCK IN SKIDTUBE CELL***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.500W.058	6061-T6 Round Tube .500 X.058W	52.5000 ft (.35 ea)	90-Start up Operation	5121423

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6T0.500W.058	53	76	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.500inches ± 0.010	0.510 0.490	Product	
2	Spacer	0.058inches ± 0.010	0.068 0.048	Product	
3	Spacer	4.145inches + 0.030 - 0.010	4.175 4.135	Product	

Plex 8/31/18 10:37 AM dart.white.jesse

DART
AEROSPACE

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S121423



Part: D4202-1

Job No: 182760

Serial No/Batch: S121423

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/25/10

RTOS 8 D VON
RTOS 8 D VON
RTOS 8 D VON



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041466

Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

PO No: PO041466
PO Date: 10/25/18
Due Date: 11/16/18

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
OCT 30 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	182760	D4202-1	Spacer : Various STC's ***HEAT TREAT AS PER DWG D4202*** Mat'l: 6061-T6 Aluminum Tubing Per WWT-700/6	Firmed	-	11/16/18	150 pcs	0 pcs	150 pcs	\$2.225/pcs	\$333.75
	182763			Firmed	-	11/16/18	150 pcs	0 pcs	150 pcs	\$2.225/pcs	\$333.75
Sub Total:							300	0	300		\$667.50

Grand Total: \$667.50

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
331457	1	132126

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
41466		AL-6061	2018/10/25	client

QUANTITÉ Quantity	No. PIÈCE Part No.	NOM DE LA PIÈCE Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
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150 D4202-1 (150) D4202-1 JOB 182760 10,75

1 BOITE DE CARTON

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE CARTON	1	

EMPAQUETAGE Packing	
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QUANTITÉ EXPÉDIÉE / Quantity Shipped : 150

POIDS EXPÉDIÉ / Weight Shipped : 10,75

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

APPROUVE

Signature:

Date:

QUANTITÉ EXPÉDIÉE / Quantity Shipped: 150

POIDS EXPÉDIÉ / Weight Shipped : 10,75

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
331457	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
41466	N/A	AL-6061		

SPÉCIFICATIONS DU PROCÉDÉ processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITY	36 - 44 %IACS	30	41 - 41,5 %IACS
HARDNESS	60 HREW MIN	30	64 - 65,5 HREW
MESURE EN HR15TW = 64,5-65,5 HR15TW (912)			

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
150	10,75	D4202-1 (150) D4202-1 JOB 182760 1 BOITE DE CARTON

ajulio

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

[Signature]



DATE: 2018-11-02

DAS
68
9-89

APPROUVE

METCOR INC.

500 BUL. ARTHUR-SAUVE, ST-EUSTACHE, QC, J8R 2A8

Tél. 450-473-1884

Télécopieur / Fax administration 450-491-2498

Télécopieur / Fax production 450-491-0424

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
331457	1

CLIENT / customer 215

DART AEROSPACE

1370 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1370 ABERDEEN

HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	CLASSIFICATION PIÈCE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
41488	N/A	AL-6061		
SOL ANNEAL SINGLE AGING TO CONDITION T42 SPÉCIFICATIONS / SPECIFICATIONS EXIGENCE / requirement CONDUCTIVITY 38 - 44 %IACS 30 HARDNESS 80 HREW MIN 30 MESURE EN HR15TW = 84.5-85.5 HR15TW (912)				
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
150	10.75	D4502-1 (150) D4502-1 JOB 182780		
		BOÎTE DE CARTON		

COMMENTAIRES / comments

DATE: 2018-11-02

APPROUVÉ par / Approved by:

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
331457	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
41466	N/A	AL-6061		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

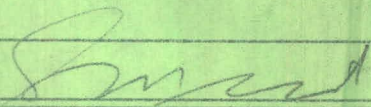
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITY	36 - 44 %IACS	30	41 - 41,5 %IACS
HARDNESS	60 HREW MIN	30	64 - 65,5 HREW
MESURE EN HR15TW = 64,5-65,5 HR15TW (912)			

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
150	10,75	D4202-1 (150) D4202-1 JOB 182760 1 BOITE DE CARTON

9/11/18

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2018-11-02

RECEIVED
JAN 10 1900
U.S. DEPT. OF AGRICULTURE
WASHINGTON, D.C.

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WASHINGTON, D.C.

